

Date: Tuesday, 10/30/2007 2:48:36 PM  
 User: Kim Johnston

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TIRE AND RIM ASSEMBLY  
 Job Number : 35436 - Estimate Number : 11156  
 P.O. Number : N/A Part Number : D32339  
 This Issue : 10/30/2007 S.O. No. : N/A Drawing Number : D3233 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 28619 Material : N/A  
 Due Date : 11/6/2007 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 10/30/07  
 Comment : Est. A 05.03.03 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 4946

For D3233-9 Tire and Rim Assembly P/N: 8353T74

Possible Supplier: McMaster-Carr

Product Specification sheet is required

C 10/31/07

(20)

2.0 8353T74 TIRE &amp; RIM



(P+D)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 Tire & Rim Assembly

3.0 QC6 DIMENSIONAL CHECK



count

Comment: DIMENSIONAL CHECK

5 7/11/05 (X6)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Identify and Stock

Location: Karl

P 7/11/05 (6)

5 7/11/05

(6)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5 7/11/05

Job Completion



C 10/31/07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7/1/02	#20	Split only 6 were removed	SP	7/1/02	6		7/1/02

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

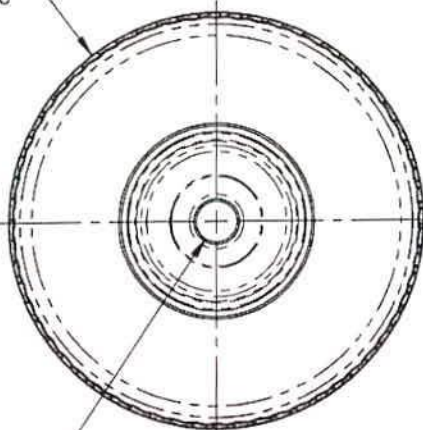
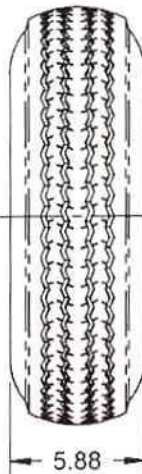
NOTE: Date & initial all entries



**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

Ø18.00

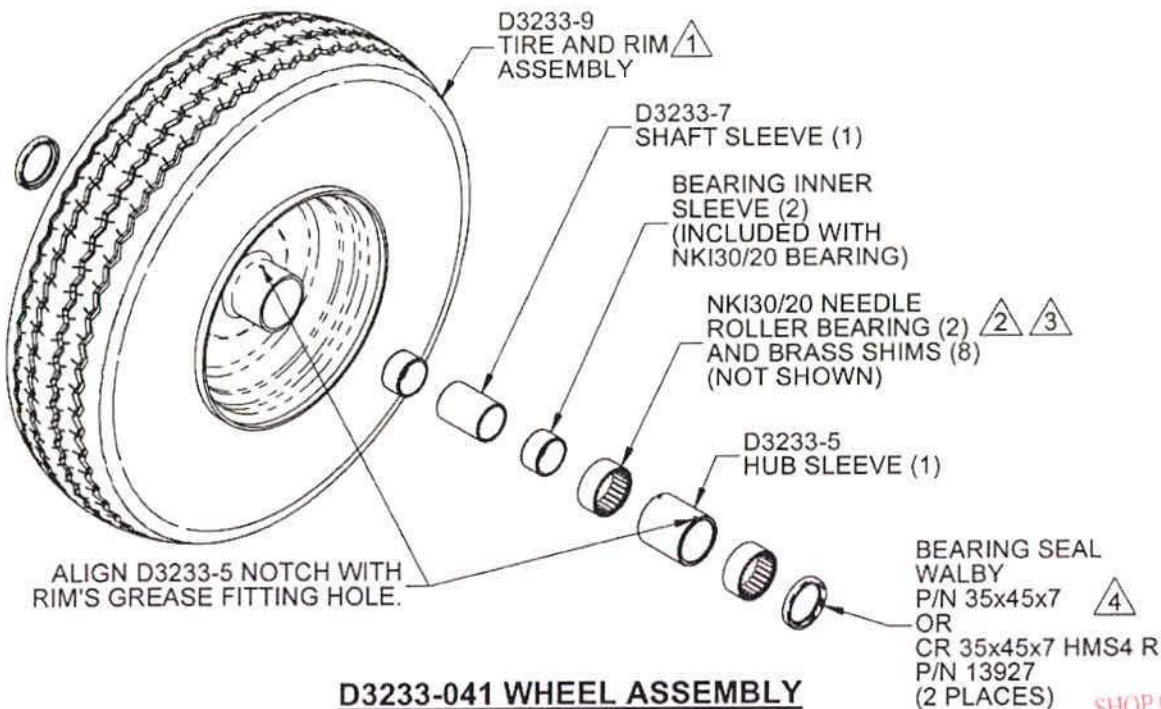
HUB  
Ø1.78

5.88

**RELEASED**  
*[Signature]*  
05/05/04

## WHEEL SPECIFICATIONS

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS  
ARE 75 PSI FOR HIGH SPEED USE.**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

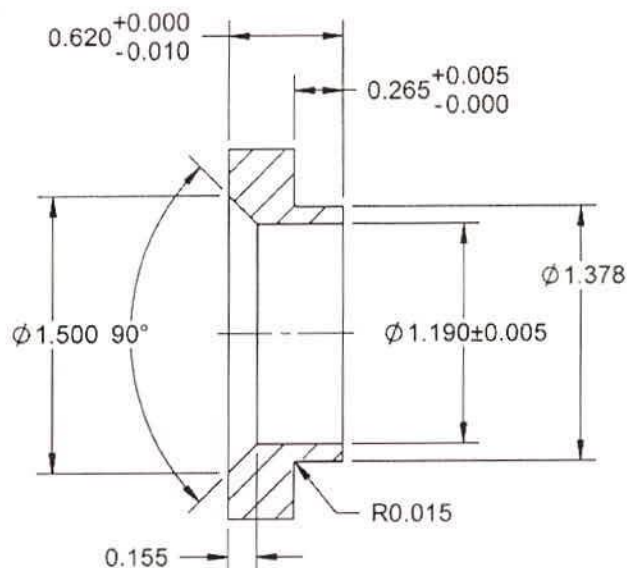
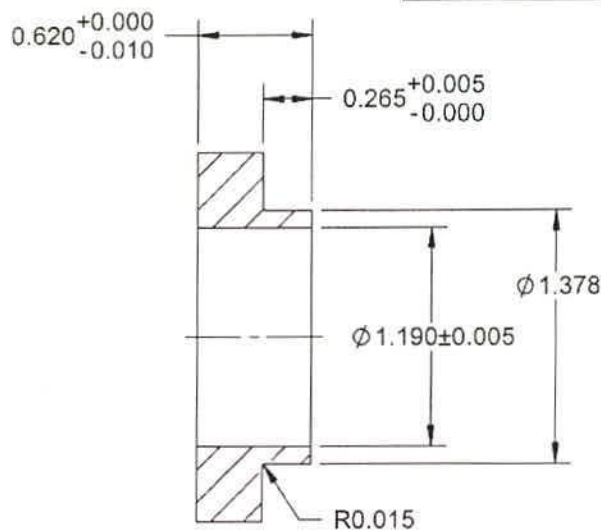
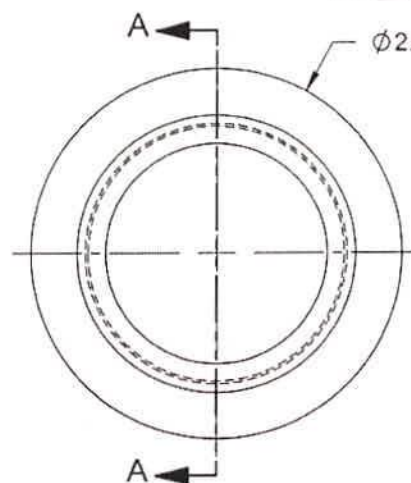
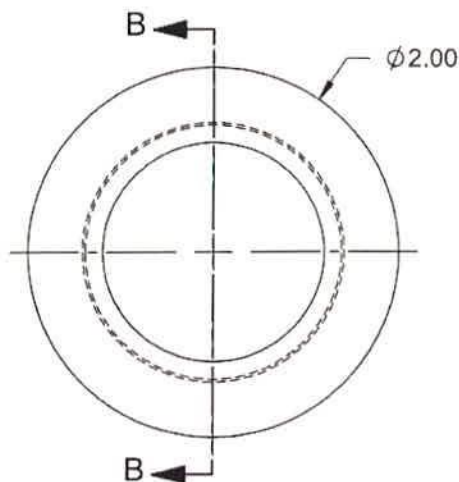
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NO. 35436

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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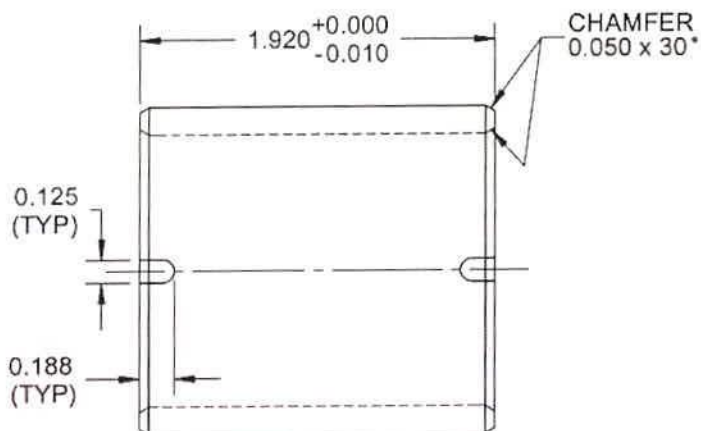
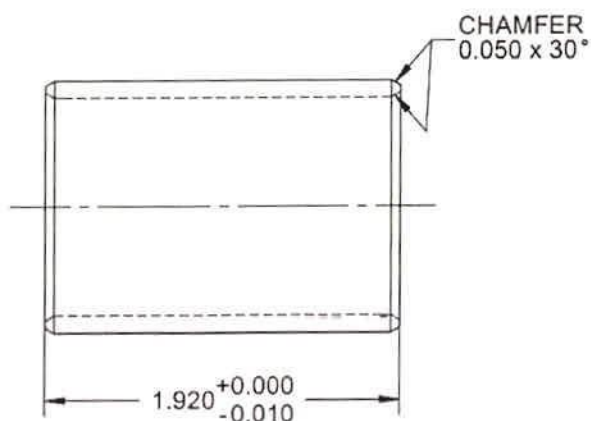
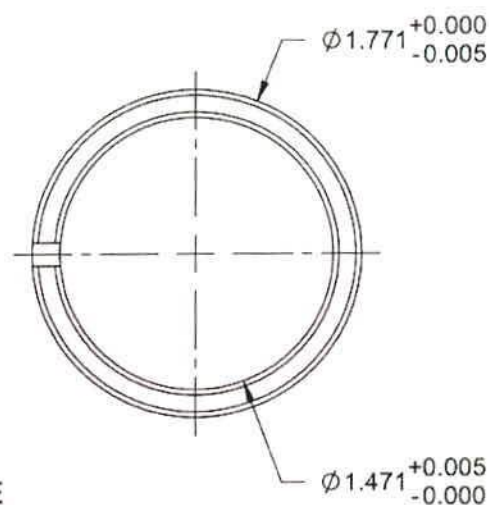
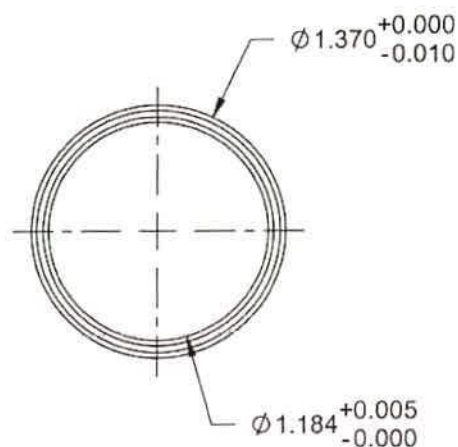
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DATE <b>05.03.08</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1:1

**RELEASED**  
WBS  
05/05/04**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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7 DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON  
MAIN FINISHED GOODS LOCATION

K6A 1

**YOUR PURCHASE  
ORDER NUMBER**

P000004946

Today's Date: 10/31/07

McMASTER-CARR  
200 AURORA INDUSTRIAL PKWY  
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS  
SHIPMENT CONTACT OUR SALES DEPARTMENT  
(330)995-5500

**PAGE**

**1 OF 1**

**MCM NUMBE**

2724757-02

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
8-79-31 47-75	8353 T74	6 EA	<p>PNEUMATIC WHEEL WITH ONE-PIECE RIM 18" X 5.9",CTR HUB,1-1/4"AXLE,ROLLER BRNG, 1590#CAP 91 RAS</p> <p>Balance of 14 EA shipped today from another McMaster-Carr warehouse CERTIFICATE OF COMPLIANCE -McMaster-Carr certifies the items on your purchase order are supplied in accordance with the description and illustration in our catalog. Compliance Manager- Alberto Valedon</p>	1	20 EA	6

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